



Dart Aerospace Ltd.
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D3651-13
Job Sheet 202478



Part No: D3651-13

Job Qty: 4 pcs

Part Name: Outside Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/29/19

Job Tracking No:

Due Date: 11/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 07-09-27 DD verified by: EC IPP Rev:B ECN 1113P 08-01-22 DD IPP
Rev:C ecn1162 08-04-02 DD verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs	11/27/19	11/27/19	0.17	1.06	Waterjet - Flow		JRB 11/5/19
110	QC 2	4 pcs	11/27/19	11/27/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S229510

Part: D3651 - 13

Job No: 202478

Serial No/Batch: S229510

Revision:

Inspector:

Exp Date:

Date: 11/05/19

Instructions: Various STC's

120	QC 8	4 pcs	11/27/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	JRB 11/5/19
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	D/
					QC 8 - 40	NOV 06 2019 4
					QC 8 - 52	9-8
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130	Packaging 3-1 - Stock - B4B	4 pcs	11/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	DAS
					Packaging 3 - 26 - B4B	21
140	QC 21 - SA	4 pcs	11/27/19	0.00 0.00	QC 21 - SA - 21	NOV 11 2019 9

		QC 21 - SA - 70		
		QC 21 - SA - 53		
Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)				
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S26GA	304/316 0.018 Sheet	2.7200 sf (.68 ea)	100-Waterjet - Flow - 1	SL55266
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S26GA	3	170	0
Part Specifications				
Specifications could not be found.				

Plex 10/29/19 9:26 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 702478
Description: Outside Doubler		Part Number: D3651-13
Inspection Dwg: D3651 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.132	✓		JRB-02	
0.260	+/-0.010	0.260	✓		Square	
2.471	+/-0.010	2.471	✓			
9.791	+/-0.010	9.790	✓			
0.634	+/-0.010	0.633	✓			
2.564	+/-0.010	2.560	✓			
0.52	+/-0.030	0.520	✓			
0.600	+/-0.010	0.604	✓			
0.500	+/-0.010	0.503	✓			
7.969	+/-0.010	7.962	✓			
2.348	+/-0.010	2.348	✓			
0.480	+/-0.010	0.478	✓			
5.571	+/-0.010	5.570	✓			
0.696	+/-0.010	0.696	✓			
7.049	+/-0.010	7.051	✓			
3.564	+/-0.010	3.563	✓			
0.694	+/-0.010	0.695	✓			
1.779	+/-0.010	1.779	✓			
8.74	+/-0.030	8.75	✓			

Measured by: JRB	Audited by: DAC 40	Prototype Approval:	N/A
Date: 11/5/17	Date: NOV 06 2019	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework Scrap Use-as-is	Skid-tube Machining Large Fab	Cross tube Small Fab Finishing	Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	Engineering Water Jet Supplier Quality
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors	Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:	Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function	Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up	Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread	